

Date: Friday, 30/11/2007 8:21:32 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG  
 Job Number : 36071  
 Estimate Number : 11683  
 P.O. Number : *NA*  
 This Issue : 30/11/2007 S.O. No. : *NA*  
 Prsht Rev. : NC  
 First Issue : *NA* Type : MACHINED PARTS  
 Previous Run : 33595  
 Part Number : D2888  
 Drawing Number : D2888 REV A2  
 Project Number : N/A  
 Drawing Revision : A  
 Material : *NA*  
 Due Date : 07/12/2007 Qty: *12* Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est. C 00.06.22 Removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X03500 6061-T6 Bar 2.5" x 3.5"



Comment: Qty.: 0.3938 f(s)/Unit Total : 3.9375 f(s)  
 6061-T6 Bar 2.5" x 3.5"  
 Material: 3.5" x 2.5" bar 6061-T6

Batch *U105212**J.L 07/12/03*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks 4.20" long  
 ( Grain along 4.20" )

*J.L 07/12/03*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio D2888  
 Deburr and Tumble

*J.F 07/12/11 (12)*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F 07/12/11 (12)*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*J.L 07.12.12*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2888 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: D Date: 07/12/13  
 QA: N/C Closed:   Date:  

NCR: <u>277</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	#30	the part scrap part was hit by tool holder. caused a flat on top of 1.13 Rad. also near the 0.760" dia hole location R.C. Hammer error -one has dim 0.375 by 2 others	<i>[Signature]</i> 05/10/12	Scrap and destroy and and Replac qty 2 B/M 165212	07/12/13 A Signin for S.F.G	<i>[Signature]</i> 05/10/12	<i>[Signature]</i> 07/12/13	<i>[Signature]</i> 07/12/13
07/12/13	#30	7 parts have Dim. 1.875" <del>#</del> @ 1.860" (0.015 off nominal)	<i>[Signature]</i> 07/12/14 05/10/12	Acceptable. PARTS HAVE SUFFICIENT CLEARANCE	<i>[Signature]</i> 07/12/14	<i>[Signature]</i> 07/12/14 05/10/12	<i>[Signature]</i> 07/12/14	<i>[Signature]</i> 07/12/14

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 8:21:33 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 36071

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

07-12-13

(X12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

M-B

07/12/17

(12X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-12

(12X)

HL

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 470

1/12/14 sup

(12X) 8

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/12/18

(12)

Job Completion



2007/12/18

W

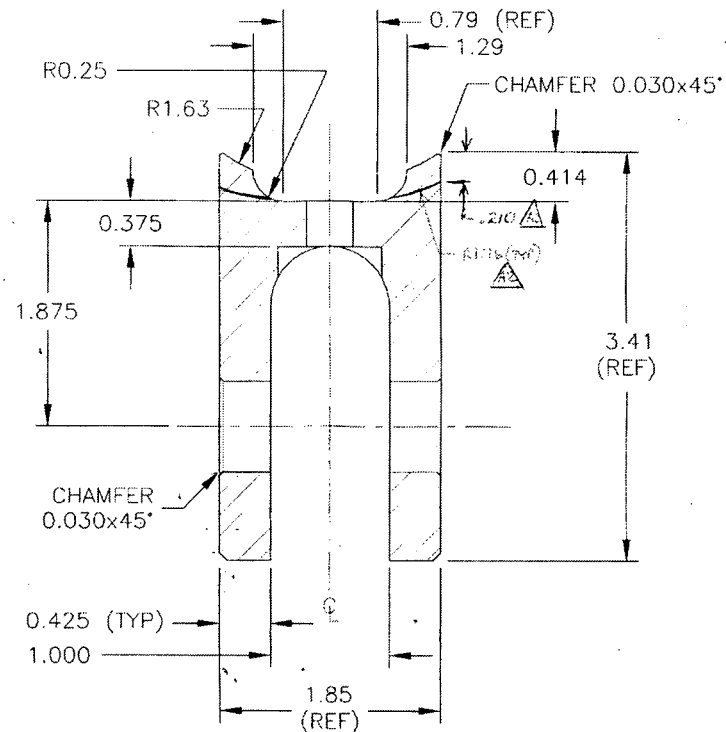
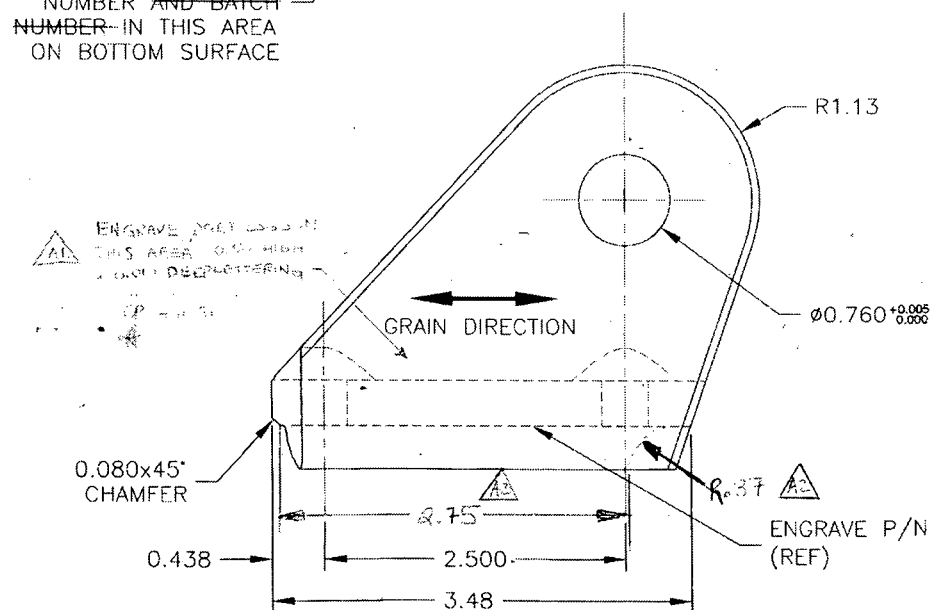
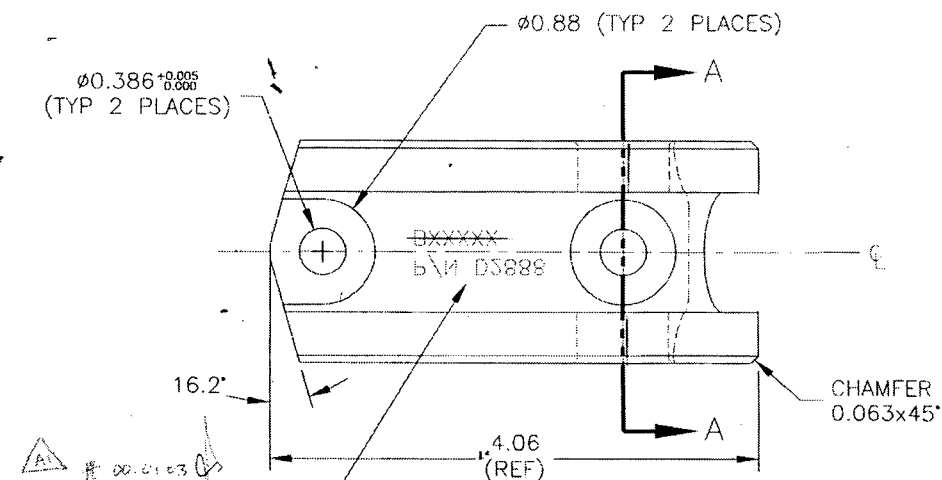
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A  
SCALE 1:1

RELEASED  
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BREAK UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE		TITLE LUG
99.06.21		SCALE 1:1

A2	09.04.08	Add Solder Clearance for WIR 754
A1	09.10.21	Industrial Engineering

1500  
3600  
1500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ.386	+0.007 -0.001	.387	✓			
φ.88	±.03	.860	✓			
.063 X 45°	±.01	.063	✓			
4.06	±.03	4.025	✓			
.080 X 45°	±.01	.080	✓			
R1.13	±.03	R1.130	✓			
φ.760	+0.005 -0.000	.763	✓			
2.500	±.01	2.501	✓			
R.25	±.03	R.250	✓			
.79	±.03	.788	✓			
1.29	±.03	1.285	✓			
30 X 45°	±.01	.030 X 45°	✓			
.414	±.01	.404	✓			
3.41	±.03	3.410	✓			
1.85	±.03	1.859	✓			
1.000	±.01	1.010	✓			
.425	±.01	.421	✓			
.030 X 45°	±.01	.030 X 45°	✓			
1.875	±.01	1.872	✓			
.375	±.01	.380				

Measured by:	S.F.
Date:	07/12/01

Audited by:	[Signature]
Date:	07-12-14

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	